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SECURITY INFORMATION

## 25X1

COUNTRY Albania

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SUPPLEMENT TO  
REPORT NO.

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THIS IS UNEVALUATED INFORMATION

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1. The title of the establishment is "Uzine Enver Hoxha, Ndermarija Shtetnore", i.e. "Enver Hoxha Works, State Undertaking" or "Uzine Enver" for short. The plant, which is the only one of its type in Albania, comes directly under the General Directorate for Mechanical Industry (Dega Mekanika) of the Ministry of Industry. It is located 1,500 meters SW of the Skanderbeg Square in Tirana, on the road leading to Durres, (See enclosures).
2. The plant, in its present form, was inaugurated on the 8th of November 1948 by Minister Tuk Jakova. It was erected on the foundations of a large engineering works planned by FIAT and begun in 1939. The work was suspended in 1940 owing to the war and resumed by the Albanian Government in 1946 almost in accordance with the original plans. As it stands at present, the existing plant is regarded merely as the first quarter of the establishment to be erected by 1955 as part of the 1951-55 plan. The remaining portions are to be built in various stages, and the second portion is to be completed by the end of 1952, next to the existing works. At a conference held on 6th November 1951, Fiqeret Shehu, wife of Minister Mehmet Shehu and secretary for the Tirana district of the Albanian Labor party, declared that the 1951-55 plan provides for the construction in the "Uzine Enver" of a blast furnace for the production of steel. It was also claimed that the blast furnace will use home-produced iron ore for which trial excavations and geological and mineralogical research are being carried out.
3. The security detachment for the plant consists of eight uniformed police armed with Italian rifles and revolvers. Although they belong to the regular police force, they are administered by the plant. Operationally, they are responsible both to the plant manager and to the police chief at Tirana. The plant covers, roughly, a square area of 160,000 m.<sup>2</sup>. The northern edge is bounded by the Tirana - Ndroq - Durres road and is closed off by a brick wall 80 cms high surmounted by a wire fence 2.5 meters high. The western and southern perimeters

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are enclosed by a wire fence only, which is 2.5. meters high. The eastern perimeter is bounded by the Tirana Military Supply Center and is enclosed by a brick wall 1.5 meters high.

4. There are about 500-550 male and female operatives employed in the plant. The technical and managerial staff numbers about 30. There are only a few score of skilled operatives; the remainder are unskilled. As long as the Government was able to do so, it employed skilled Italian labor. In order to overcome the present lack of skilled Albanian labor, Russian and Czech engineers are being engaged on one or two-year contracts.
5. The plant manager is Artion Spartak, a native of southern Albania aged 50. He left the country in 1923 or 1924 after the formation of the first independent Albanian Government and went to Italy and then to France, eventually reaching the U.S.S.R. He finally returned to Albania in 1949. In Russia he was employed as an operative, then became a trade-union delegate, a member of the Party and a propagandist. Originally a Moslem, he renounced his religion and proclaimed himself an atheist. He has married a Russian woman and speaks perfect Russian. He is a member of the Albanian Workers' Party and the Citizen's Committee of the Party for Tirana. He is intelligent and versatile but at the same time reserved. 25X1  
 He lives in a house in New Tirana. His functions inside the factory are purely administrative and political, not technical. His staff consists of a shorthand typist and a secretary.
6. The assistant manager is Ferid Luka, whose tasks include the provision of the raw materials requested by the planning office. Being head of the political office, and therefore political commissar, he is also responsible for political activity inside the plant.
7. The director of the technical branch is a chief engineer. The post is vacant at present, the previous holder, the Soviet engineer Ivan Sallov, having been repatriated in October 1951 on expiration of his two-year contract. It is thought that the new chief engineer will also be a Russian. Under the chief engineer there is a metallurgical engineer in charge of the foundry. This post is vacant at present. It was held by a Soviet engineer up till the 10th or 15th of December 1951, when he was repatriated on expiration of his one-year contract. A Czech engineer, formerly of "Skoda" at Prague, was engaged in the summer of 1951 on a yearly contract for the foundry. His contract will expire in the summer of 1952. 25X1
8. The director of the planning office is Dimitri Bidulli. 25X1  
 He has a staff of four clerks. The office draws up an "annual production plan" in consultation with the chief engineer based on contracts and orders, and on the instructions issued by the Ministry of Industry for the implementation of production plans. This annual plan is then sub-divided into monthly plans and passed on to the production office, which forwards them to the departments concerned, which in turn breaks them down into fortnightly and weekly plans, and into "daily norms" for branches and individual operatives. The planning office is also responsible for requisitioning, from the assistant manager, the supply of materials required for the production cycle of the whole plant. The functions of the office are administrative and not technical.
9. The staff of the administration office consists of a chief and four clerks, including a woman and a cashier. The office deals with all administrative matters concerning staff and running expenses.
10. The office staff of the production office consists of a chief and eight technical clerks. It is divided into a technical office, technological office and an "ufficio di pianificazione". The chief of the production office is Doco Caci, a native of the Fermet area, aged 30. He was in the Kucove camps until the end of 1942, when he became a Communist activist, without however joining the Albanian army of national liberation. He performed his normal military service in 1948

and was subsequently employed as a lathe operator at the State plant No. 4, until they were disbanded, when he was employed by the "Enver Hoxha Works." He was elected secretary of Tirana district No. 2 on the occasion of the Tirana district elections held in September or October 1948, when he left his job at the "Enver Hoxha Works." The fall of Koci Xoxe appeared to have a negative effect on Koco Caci's political career, because immediately after the death of the Minister he returned to the "Enver Hoxha" plant as foreman. In February 1950, he was made chief technician and in April 1950 was placed in charge of the production office. He is a member of the Communist Party and a trusted follower of the Government's policy. He is also in charge of the entire production of the plant and is personally responsible for the maintenance of production plans. He attends evening classes in Tirana. A sister of his, Lefteria Caci, is head of the "plant professional office" ( see paragraph 18 below ). Koco Caci has his own secretary.

11. The technical office has a director and two draughtsmen. The director is an industrial expert named Zydi Juma: he is a non-Communist. Of the two draughtsmen one is an industrial expert while the other one is an apprentice. The task of the office is to convert the plans received from the planning office into designs and technical measurements.
12. The technological office has a director and a clerk. The director is an industrial expert with a diploma from the American technical school at Tirana. A non-Communist, he is 33 years old and a former soldier in the Italian army who subsequently became a regular officer at Piacenza. He returned to Albania in 1942. The clerk is a fanatical Communist. The office has the task of examining the plans drawn up by the technical office and suggesting machining methods, ways and means of carrying out the job, and the materials required.
13. The "Ufficio di Pianificazione" ( or "Contracts Office" ) has a director and a clerk. The director is Loro Biduci, a non-Communist, who attended the Italian technical school at Tirana; however, he did not finish the course. The office receives orders and draws up production contracts with the Ministries, with private persons, and with the other nationalized industries.
14. The personnel office has a director who is the only member of the office. For routine work he uses the services of the secretary and of the shorthand typist in the management office.
15. The delivery office is in charge of a woman, who is a member of the Party. The office receives the finished products from the various departments and despatches them to the organizations or industries who ordered them.
16. The director of the checking office is Riza Bermena, a Moslem aged 30 and a member of the Party from Tirana. There are five checkers including one woman. The office tests the products before passing them as up to standard. It is equipped with a machine for measuring resistance to tensile stress, two Brinnell machines for measuring the hardness of materials and various precision instruments (fixed and mobile calipers, micrometers, "comparoscopes", percussion pins, etc.).
17. The chief of the warehouse is a member of the Party; under him he has a staff of four porters. Administratively, the warehouse comes under the administration department, and for all other purposes under the Assistant Manager. The warehouse receives all the materials which arrive at the works for processing, etc., and all the departments concerned withdraw such materials from the warehouse according to existing production and consumption plans. The warehouse is equipped with a fixed electric hoist with a lifting capacity of three tons.

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18. The professional office handles the factory trade-union section, which is directed by Lefteria Caci with the assistance of a workers' committee. Caci was appointed to this job by the directorate of the central office of the unified Albanian trade-union and is paid a regular salary by the directorate. The office has no trade-union functions comparable with those of a trade-union in a free country. Its functions are administrative and executive: qualification courses for operatives; moral and physical welfare; inspection of the sanitary services inside the factory; supply of medicines and funds for the factory sanitary service; arrangement of the annual holiday and rest periods so as to ensure that every operative is granted his entitlement; choice of the more deserving members of the staff to be sent to climatic or health resorts, with particular reference to those who have distinguished themselves by their political conduct and their performance at work; sports activity; cultural courses.
19. There is also a political office which is, to all intents and purposes, the political commission of the factory. It controls the political activity of the whole staff. The office is in charge of Ferid Luka, whose staff consists of Artion Spartak, Koco Strakoco, Xhelal Cyteza, age 30, Lefteria Caci, and an operative from the foundry.

a. Lathe Section

- (1) The lathe section is equipped with the following:

- 2 small American lathes
- 3 small Russian lathes of recent construction
- 1 vertical Italian lathe
- 14 medium German lathes of good quality
- 1 vertical Czech lathe of an old type
- 3 medium Russian lathes of recent construction
- 1 large lathe for turning objects up to 100 cm.

The remaining lathes are of an antiquated pattern and are not all serviceable. They include:-

- 6 automatic turret lathes
- 6 unserviceable turret lathes
- 1 large vertical lathe
- 1 medium vertical lathe
- 2 bolt threading machines for diameters of  $\frac{1}{2}$  in. to 2 in. with scale in inches and mm.
- 2 large German circular saws, including one operated by oil pressure and capable of sawing steel up to 400 mm; the other one with automatic feed motion capable of sawing steel up to 300 mm.
- 4 horizontal blade saws with horizontal slide, capable of sawing steel up to 200 mm.

The large lathes are capable of turning items up to 1,000 mm.  $\phi$ ; the medium ones can handle items of 150 mm. to 300 mm.  $\phi$ , and the small ones items up to 150 mm.  $\phi$ .

The machinery, apart from the lathes of the old type, some of which are not being used, is of good quality.

- (2) The lathe section is staffed by one foreman, two assistant foremen and about 200 operatives. There are approximately two workmen for every machine being

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operated. The operatives are divided into ten so-called "Brigades" which correspond more or less to the squads or teams in Western factories. There are brigades for:

- Aluminum pistons
- Bolts
- Bushings
- Axles and gears
- Miscellaneous production
- Industrial production
- Piston rings for motor vehicles
- Industrial piston rings
- Turret lathes
- Special employment

- (3) The foreman is Xhelal Cyteza, a Moslem aged 30 from Korcano. He is a member of the political office at the works. He has no particular technical qualifications, and his functions are purely administrative and political. The two assistant foremen are Ali Kraja, a Moslem aged 26 from Shkoder, a fanatical Communist, and Dmitri Anxhari, a native of Tirana aged 22, a member of the Rinija, the Communist Youth Movement.
- (4) Two shifts are being worked in the lathe section:
- a) from 0600 - 1100, and from 1230 - 1530 hrs.
  - b) from 1530 - 1900, and from 1930 - 2400 hrs.
- Each shift is in charge of one of the assistant foremen.

The operatives handling the machines are not sufficiently skilled and are unable to use them to their full advantage. Therefore, in spite of the machinery being fully effective, the output includes a high percentage of waste.

b. The Milling, Planning, and Gridding Shop

This shop is divided into four departments: milling machines, planing machines, grinders and shaping machines.

- (1) The milling shop is mainly employed on the machining of gears. The equipment comprises:
- 1 universal milling machine of Italian pattern
  - 1 universal milling machine of Russian pattern
  - 1 universal milling machine of German construction
  - 4 German small-capacity universal milling machines
  - 1 automatic milling machine for straight teeth, old pattern
  - 4 milling machines, old pattern
  - 1 German vertical milling machine of good quality
  - 3 German vertical milling machines, old pattern.
- (2) The grinding shop grinds gears, axles, transmission shafts, pistons, etc. It comprises:
- 1 automatic gear-grinding machine of German pattern built in 1943-1944. It has never been used owing to the absence of a part.
  - 1 German grinder for holes up to 400 mm  $\phi$ . Operated by oil pressure.
  - 1 grinding machine for crankshafts, of American construction
  - 1 grinding machine for straight axles, of recent American construction
  - 3 grinding machines for axles. The machines are of an old pattern and of little use.
  - 2 German vertical grinding machines with magnetic table
  - 1 American vertical grinding machine with magnetic table

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## (4) The shaping shop comprises:

- 1 Russian shaping machine with a stroke of 60 cms.
- 1 German shaping machine with a stroke of 30 cms.
- 2 German shaping machines of old pattern.

## (5) The staff of these departments consists of a foreman and 20 operatives. The foreman is Kilija Margariti, a non-Communist who has studied at Greek industrial and technical schools and also worked in Greek factories for many years. He speaks Greek and Albanian. One shift of eight hours is worked in these departments.

c. The Adjusting Shop

## (1) The adjusting shop has the following equipment:

3 radial drilling machines; of these two have arms of 1.2 meters and drills for producing holes up to 50 mm  $\phi$ . The third has an arm of 1.7 meters and drills for producing holes up to 60 mm or 70 mm  $\phi$ .

1 pillar drill with four independent drillstocks for holes up to 20 mm  $\phi$ .

2 pillar drilling machines with a single drillstock each, for holes up to 30 mm  $\phi$ .

1 combined shearing machine (shears=press) for the cold shearing of metals (plates, profiles etc.) up to 10 mm thickness and 30 mm  $\phi$ .

3 mechanical cold stamping presses. Of the three, only two are in operation, the third one being without an electric motor. Details of pressures are lacking but are believed to be between 100-120 kgs/cm<sup>2</sup>. Only light work is carried out.

9 emery grinders (located in other shops)

7 tool grinders (located in other shops)

5 work benches with 6 vices to each bench.

## (2) An average of 30 operatives are employed under the foreman Dimitri Giro, a non-Communist aged 42 from Ciamuria, who has worked at the "Enver Hoxha" plant since 1949. He has studied at a Greek industrial school and also worked in Greek factories. The number of operatives varies because many apprentices are attached to this shop. As soon as they have learned the trade they are transferred to other shops within the works or to other industries at Tirana. A single shift of eight hours is worked in this shop.

d. The Forge

## (1) The forge has the following equipment:

1 trip hammer with a striking power of 250 kgs per cm<sup>2</sup>, old pattern

1 trip hammer with a striking power of 70 kgs per cm<sup>2</sup>

1 trip hammer with a striking power of 50 kgs per cm<sup>2</sup>

1 Russian type trip hammer of recent construction with a striking power of 125 kgs per cm<sup>2</sup>.

1 spring hammer of an out-of-date pattern, in course of installation at the beginning of December 1951

3 German reverberatory furnaces. Internal capacity 60 cm<sup>2</sup>, up to 1,200 °C

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1 diesel-fired carburizing furnace of 1 cu. meter for temperatures up to 1,200°C, also adaptable for hardening purposes.

2 horizontal mechanical presses, probably to begin operation in March 1952

1 rolling mill for cold treatments and for thicknesses not exceeding 5 mm. useful length 150 cms.

1 circular saw for sheets up to 300 mm thickness

1 mechanical shearing machine for sheets up to 10 mm thickness. Useful cutting edge 150 cms

1 vertical drilling machine for holes up to 30 cms Ø

1 adjusting bench with 6 vices

5 forges of 1.2 m<sup>2</sup> each operated by a single electrically-driven fan

2 electric steel tempering furnaces. They have not yet been used owing to the lack of pyrometers, which have been ordered in the U.S.S.R. but which have not yet been delivered.

2 hand-operated trucks with a carrying capacity of 0.5 tons each.

- (2) There are 25-30 operatives employed under the foreman Nikola Bonci, a White Russian aged 50, who has lived in Albania for more than 20 years and has acquired Albanian citizenship. He has attended Russian industrial schools and worked in French factories. He speaks Russian, Italian, French and Albanian. He is not a Communist. The shift of eight hours is worked in the forge.

e. The Foundry

- (1) The foundry has the following equipment:

1 cast iron cupola furnace of German construction with a capacity of 2 tons

1 coke-fired Italian Ansaldo cupola furnace with a capacity of 0.5 tons

1 coke-fired Italian cupola furnace with a capacity of 0.3 tons

2 earth crushers for the making of moulds

1 mechanical earth sieve

1 hydraulic press ( in course of installation)

1 mechanical press ( in course of installation). Both presses will be used to press earth for the production of moulds

1 air compressor ( in course of installation), to be used for cleaning castings

4 crucibles for the melting of aluminum and bronze.  
Each crucible has a capacity of 100 kgs and is coke-fired

1 electrically-driven trolley with a carrying capacity of 0.75 tons, serving the two cupola furnaces of 0.3 and 0.5 tons

1 electrically-driven trolley with a carrying capacity of 0.5 tons each (under construction). They will serve the four bronze and aluminum crucibles

1 electric hoist of 1.5 tons lifting capacity, used to load the cupola furnaces.

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- (2) The foundry staff consists of a foreman and 150 operatives, including ten women. The foreman is Vangel Peristeri, a southern Albanian aged 45. Outwardly a Communist, he cares little for political matters. He is a competent technician and speaks Albanian, Greek and Italian. [redacted] 25X1

[redacted] two shifts of eight hours each are being worked in the foundry.

f. The Pattern Shop

- (1) This shop, which prepares the wooden patterns for the foundry, is equipped with the following machinery:

2 wood lathes  
1 band saw  
1 combined machine, with 1 circular saw and 1 wood cutter  
4 working benches.

- (2) The shop employs 13 operatives, including one woman, and a foreman. The foreman's christian name is Tonin (surname unknown); he is a Catholic and a non-Communist. He is not a member of the Party and never bothers about politics. He speaks good Italian. A single shift of eight hours is being worked in this shop.

g. The Electrical Workshop

- (1) This shop is responsible for the maintenance and repair of all electrical installations and motors in the plant. It does not produce any electrical equipment of its own.

- (2) The staff consists of a foreman and six electricians. The foreman is Niko Laci, a native of Korca aged 25, who has attended the Italian industrial school at Korca. [redacted] 25X1

[redacted] He was a 2nd Lt. in an Italian engineers unit stationed in Albania and later became a Lieutenant in the Albanian army of liberation. He is intelligent and capable as well as a good electrician. He has a fair knowledge of radio and wireless technology and is a capable wireless operator. 25X1

h. The Maintenance Shop

This shop is responsible for the overhaul and maintenance of all machines in the plant. It employs a foreman and about 20 operatives. Their number varies considerably because they are frequently transferred from one department to another. The foreman is Koco Strakoco, member of the Communist Party, Italian speaking. He was formerly the manager of the "Enver Hoxha Works" before being replaced by the present manager, Artion Spartak.

21. Production and output for the plant is listed separately below for each shop and "brigade." Unless otherwise stated, the figures quoted represent the average monthly production for 1951.

a. Turning Department

- (1) First Brigade (aluminum pistons)  
400 motor car pistons of 60 mm to 120 mm  $\phi$ . The most common types of pistons produced are for the "Fiat 1100" car, jeeps, lorries of the "Fiat 634", "OM" (60 and 120 h.p.), "Praga", "Zis" (3-ton), "Skoda" (4-ton), "Tatra"

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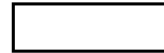
(3 and 6-ton), "Berliet", "Renault", "Ford" (3-ton) and "Chevrolet" types, and for tractors of the "Caterpillar" (100 h.p.) type.

- (2) Second Brigade (bolts)  
3,000 round-headed bolts of 0.5 in. to 1 in.  $\phi$ , and of 50 mm to 1,000 mm in length, for wood and steelwork.
- (3) Third Brigade (bushings)  
2,000 bushings, the majority of them for motor car engines, of various sizes and in various alloys, according to the orders received. The alloys required are supplied by the foundry.
- (4) Fourth Brigade (axles and gears)  
The greater part of the output consists of spares for gear boxes for lorries and private cars of the makes stated above. Production is limited to: gears with straight teeth, gears with helicoidal teeth, bevel gears with straight teeth, axles, half-axles (excluding differentials and parts thereof). Output: 200 parts for gear-boxes of various types and 400 axles or half-axles of various types and measurements.
- (5) Fifth Brigade (miscellaneous production)  
Pulleys, axles for industrial purposes, straight transmission shafts, plough wheels, axles, wheels and bearings for narrow-gauge railways, piston pins. Production figures cannot be quoted since they vary considerably. On an average the output of this shop accounts for 20% of the total output of the turning department. The shop also produced the axles, wheels and bearings for the industrial railway between Vlone and Selenice built for the transport of bitumen to the port of shipment.
- (6) Sixth Brigade (industrial production)  
The shop produces:  
Injection pumps for diesel engines of the "Tosi" type, used in the Kucove oilfields. Two such pumps were built in 1951 and the 1952 plans provide for the construction of a further four.  
  
Pistons for Russian "C.T.Z." agricultural tractors of 80 h.p. Dimensions of pistons: length 135 or 140 mm,  $\phi$  112 mm. Average output 30 pistons a month.  
  
Cast iron pistons for diesel engines installed in electric power stations and elsewhere, of 200 mm to 400 mm  $\phi$  and of 250 mm to 1,000 mm in length. Average monthly output: 15 pistons of various sizes.  
  
Cast iron liners for the above-mentioned cylinders in the corresponding  $\phi$  and up to 1,700 mm in length. Average monthly output: 15 liners a month of all sizes. The pistons and cylinders are specially built for the following types of diesel engines used in Albania:  
  
"Tosi" (type "H"), "Tosi" (type G.4), "Tosi" (type L), "Tosi" (type Q.2), "Tosi" (type Q.1); "MANN" (German and Russian manufacture, produced by Russian or German factories in the Eastern zone of Germany); "Deutsch" and "Deutschgewerk" (Kiel), "Graz", "San Giorgio" (Genoa), "Modak", (Krupp), "Bukey" (U.S.A., supplied by UNRRA), "Kirov" (Russian, supplied recently).
- (7) Seventh Brigade (piston rings for motor vehicles)  
4,800 rings a month. The shop manufactures rings for the pistons produced by the Aluminum piston shop. As a rule 12 rings are manufactured for every cylinder produced.

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- (8) Eighth Brigade ( industrial piston rings)  
1,800 piston rings for industrial diesel engines. The shop produces rings for the pistons built by the "industrial production" shop. As a rule 40 rings are manufactured for every piston.
- (9) Ninth Brigade (turret lathes)  
1,200 Aluminium piston pins for the motors of the vehicles previously mentioned.  
600 steel bushings for tractor tracks, for vehicles springs and bearings.  
5,000 bolts and nuts of 9.5 mm to 15.8 mm  $\phi$  and 35 mm to 37 mm in length for ploughs.
- (10) Tenth Brigade (special employment)  
The shop was founded in 1948 by the Italian Mario Massarini for the purpose of making injection pumps of the "Bosch" type for tractors and lorries from second-hand and worn-out parts. The results achieved were satisfactory, bearing in mind the shortage of this type of equipment in Albania, but in spite of this the pumps were never produced systematically. It would appear that this special brigade, which is at present engaged on ordinary engineering tasks, will revert to its original functions under the direction of a foreign or Albanian specialist trained in the U.S.S.R. or in Czechoslovakia.

b. Milling, Grinding, and Planing Shop

This shop merely finishes and completes the parts produced by the turning department and the adjusting shop. It therefore has no production figures of its own.

c. Adjusting Shop

This shop assembles animal-drawn ploughs, the individual parts of which are manufactured in the forge and turning department. These ploughs are copied from an American type supplied to Albania by UNRRA, with a single ploughshare 25 cms high and 50 cms long. The monthly output of ploughs is in the neighborhood of 600. The shop also finishes and completes the parts produced by other shops.

d. Forge

Forging of axles, gears, and agricultural implements ( axes, hammers, hoes, pick-axes, etc.) and other simple tools and machines. The aggregate monthly output of small worked parts amounts to 2 tons. A special department of the forge is devoted to the manufacture of all metal parts for ploughs. The above-mentioned monthly production average includes the metal parts for 600 ploughs.

e. Foundry

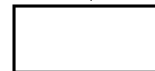
- (1) Cast Iron: Four to six tons of virgin pig iron are cast every month. Castings are made once every three days in various furnaces, which are used in rotation. The output is divided into small and large castings. The former comprise rings, pistons, and sleeves for diesel engines and various castings; the latter include mainly furnaces for the smelting of copper ore; four of these were built during 1951 for the Albanian copper mines at Rubik. Four furnaces for the smelting of bituminous ores from the Albanian industry (Selenice) have been built each month during 1951, and the 1952 plans provide for the maintenance of this rate of production.
- (2) Aluminum: Aluminum castings for finishing by the aluminum piston shop of the turning department. The quantity produced every month equals the figure quoted in respect of finished pistons, plus 10% in respect of rejects.
- (3) Bronze: The foundry supplies the bushing "brigade" of the turning department with the necessary castings. The quantity produced equals the output figure quoted for the bushing "brigade", plus 10% to provide for rejects.

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(4) The foundry also produces aluminum and bronze castings for finishing in other departments of the works, or for sale in the unfinished state to other Albanian industries. Bronze castings of this type equal 30% of the bushings produced, while the percentage in respect of aluminum castings amounts to 20% of the aluminum pistons produced.

22. Among the factors which hinder output, the most important is the lack of skilled labor. In the case of castings, the rejects amount to 25% of total production on an average, and during certain periods and in certain departments, may reach as much as 50% (details are lacking). Even the finished products which have been tested and declared to be up to standard contain flaws which reveal themselves after the article has been put into use, necessitating frequent retouchings and renewals.
23. The entire output of the plant remains inside the country. No distinction can be drawn between production for civilian and military purposes, since in addition to the items which are ordered and delivered to other nationalized undertakings, there are products which are ordered directly by the Ministries of Industry and Transport. It may be, therefore, that these latter goods are subsequently used for military purposes without the knowledge of the works' management. The Albanian armed forces have their own small maintenance and repair workshops, and it is only on rare occasions that a direct request is made to the "Enver Hoxha" plant for assistance, particularly as the U.S.S.R. supplies all the spares for weapons and vehicles of Russian construction on issue to the Albanian forces. Only on one occasion, in 1951, did the plant manufacture a half-axle for a Russian tank, but the work was carried out according to the design and direction of a Russian military inspector.
24. All machines in the plant are electrically-driven. The plant has no power plant of its own and is supplied from the local mains. The current is of the three-phase type, 5,200v. at the intake. The voltage is reduced in two transformer stations equipped with five transformers. The two stations are equipped with the following plant:
  - 2 transformers of 100 kw
  - 1 transformer of 100 kw
  - Distribution panel, measuring instruments and hand-operated switches. The current is reduced in three stages to 380 v for the motors, plus a neutral phase of 220 for lighting purposes.
  - 2 transformers of 50 kw each
  - Switches, valves, meters.
25. Almost all raw materials are supplied by the U.S.S.R. and only a small proportion by Czechoslovakia. The U.S.S.R. supplies: coke, aluminum in ingots, bronze in ingots, drawn bronze, virgin cast iron, nickel-chrome steel, carbon steel, hexagonal bars for the manufacture of bolts, high-speed steel, and "widio" (sic) steel.

The following marks have been seen stamped on the unworked metals supplied by Russian factories to the "Enver Hoxha Works":

- |        |   |
|--------|---|
| E.Y. A | Special steel (vanadium steel) for injection pumps  |
| 40     | Tempering steel (supplied in large quantities and frequently used)                        |
| 5      | Steel containing a high percentage of carbon, soft, but not suitable for water tempering. |
| 80     | Tempering steel   |
| C.25   | Nickel-chrome steel for the manufacture of engine valves.                                 |

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-12-

25X1

25X1

25X1

1. [REDACTED]

25X1

2. [REDACTED] Comment: It is not clear how the production office differs from the planning office (ufficio pianificazione mentioned in paragraph 13) according to the tasks it performs, a more suitable name for the latter would be "contracts", or something similar.

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LEGEND

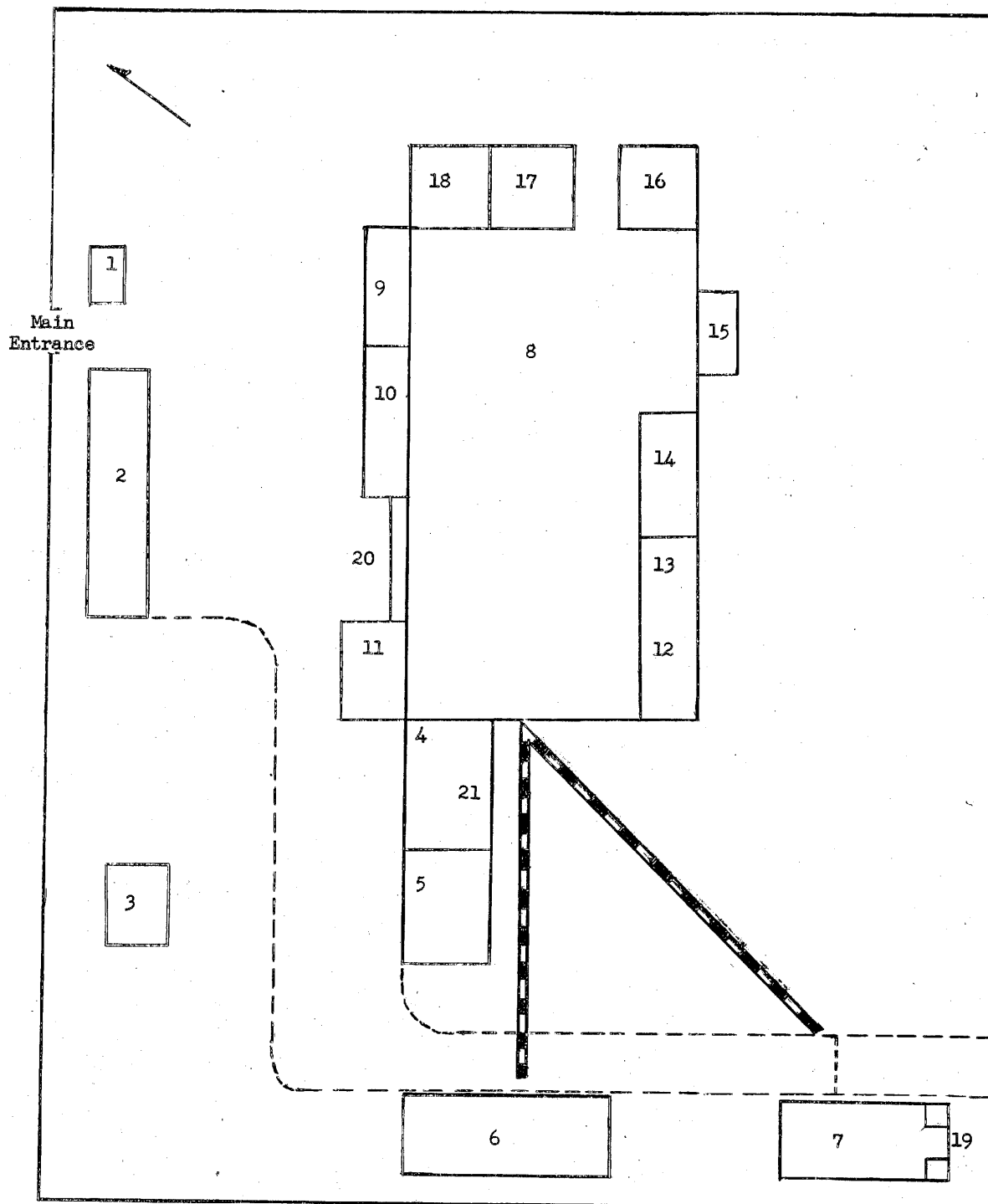
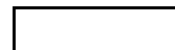
1. Guard post, an iron kiosk belonging to a former gasoline station and now used by the police.
2. A small wooden building measuring 20 x 8 meters used partly as a store for old and derelict material, partly as living quarters for the guards.
3. A small wooden building of the Italian "Palini" type, built on a brick foundation and used as a recreational center for the workers.
4. Square single-story building of 20 meters lateral dimensions used as a store for all metal materials required by the factory.
5. Single-story brick building measuring 5 x 6 meters containing laboratories and a store belonging to the wood pattern-makers' shop.
6. Brick building measuring 40 x 12 meters with two internal bays of 6 meters each containing the foundry. Some offices are housed on the upper floor.
7. Brick building measuring 20 x 10 meters with two bays of 5 meters each, containing the forge.
8. Main shop. A brick building measuring 45 meters long, 40 or 42 wide and 10 high with six rows of vertical window lights facing south. The building is divided into six bays containing the various departments.
9. Annex to main shop containing the electrical workshop.
10. Annex to main shop containing store and distribution office for processed parts.
11. Building containing the offices of the management and of the technical-administrative staff.
12. Area separated from the main shop, containing the motor overhauling department.
13. Area separated from the main shop containing the special department (research, appliances).
14. Tool store.
15. Annex to main shop containing a store. The building was erected to house the planned central heating plant and the compressed air generators.
16. Annex to main shop containing dressing rooms for male workers.
17. Annex to main shop containing dressing rooms for female workers.
18. Main transformer station with three transformers of 100 and 200 kw.
19. Transformer station for foundry and forge, with two 50 kw transformers.
20. Fixed electric hoist of 6 tons lifting capacity.
21. Fixed electric hoist in the materials store.
22. Electric travelling hoist of 1.5 tons lifting capacity for the loading of the cupola furnace in the foundry.

ENCLOSURE 1

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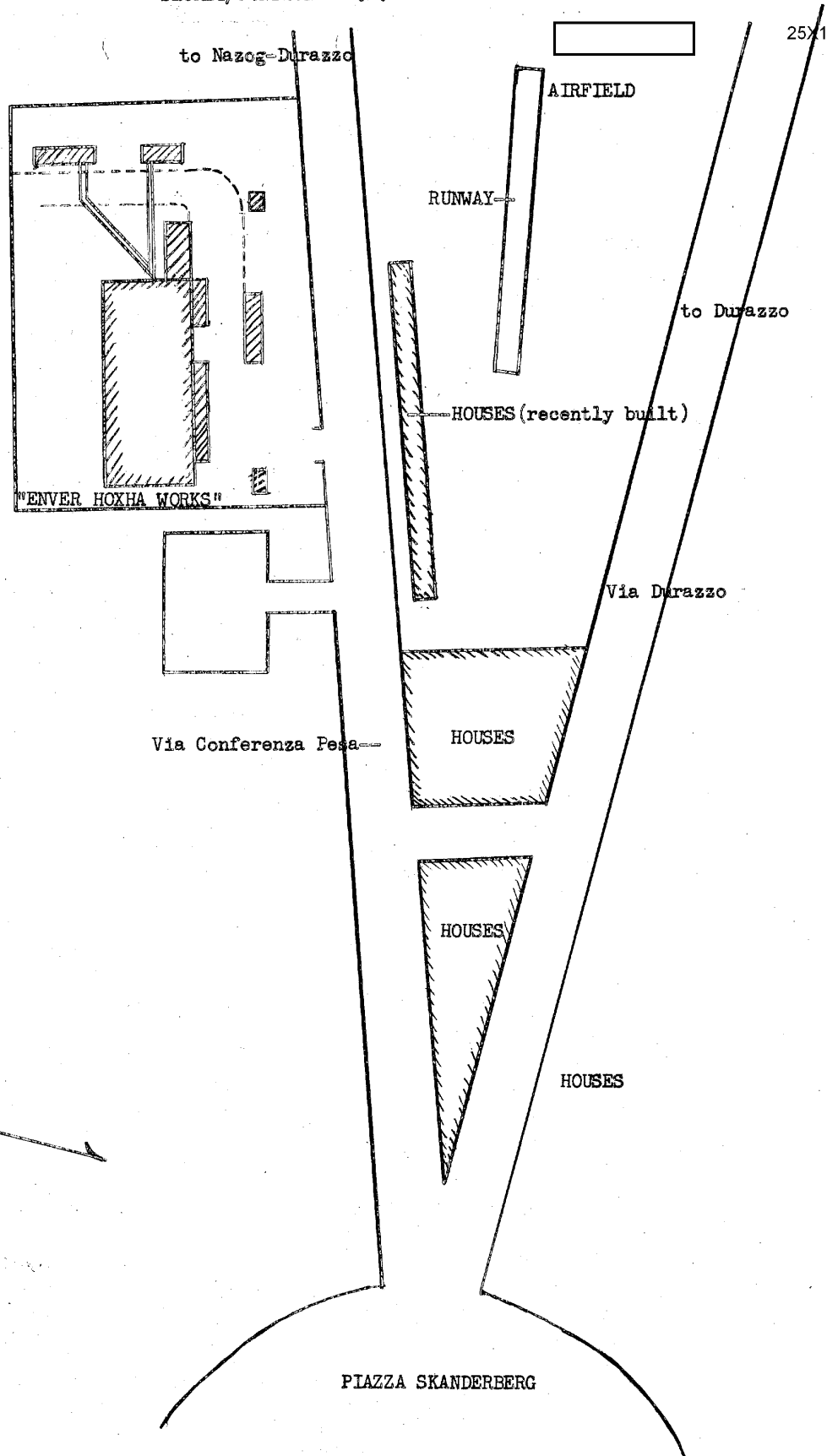
"ENVER HOXHA WORKS"

TIRANA

ENCLOSURE 2

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TIRANA

ENCLOSURE 3

Sketch showing position of  
"ENVER HOXHA WORKS"  
(NOT TO SCALE)

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